

Work Order ID 79717

February-01-12 8:14:51 AM

79717

Page 1

Item ID: D2573

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft Out 205

Start Date: 01/02/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 21/02/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/01 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 379717 Double check by: RT 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RT 12-03-02 (x12)

RT 12-03-04 (x12)

RT 12-03-04 (x12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79717

February-01-12 8:14:51 AM

79717

Page 2

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 01/02/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 21/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8h45 320°F OVEN TEMPERATURE: 9h15 FINISH TIME: _____								

m 120222

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79717

February-01-12 8:14:51 AM

79717

Page 3

Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft Out 205

Start Date: 01/02/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 21/02/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 X / 12/03/08
COU(OT)

170

Identify as per dwg & Stock Location: 433

0.00

170

Packaging

Memo

0.00

Packaging

12/03/08 (12)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12-03-8
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-01-12 8:14:56 AM

Page 1

Work Order ID: 79717

79717

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 01/02/2012

Required Date: 21/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	10.0000	1	12			

D6101-007

Saddle Billet

29 12 3 2

Location

Loc Qty

Loc Code

MAT045

10

70680

3

76839

7

79889

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

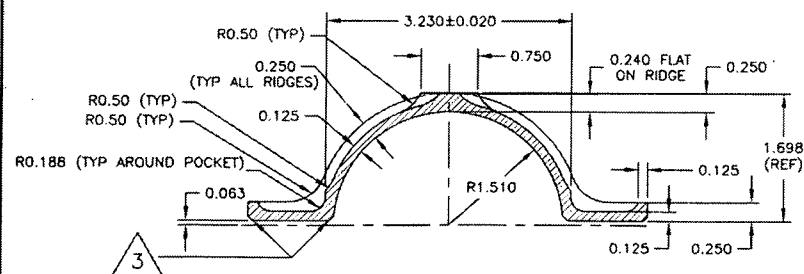
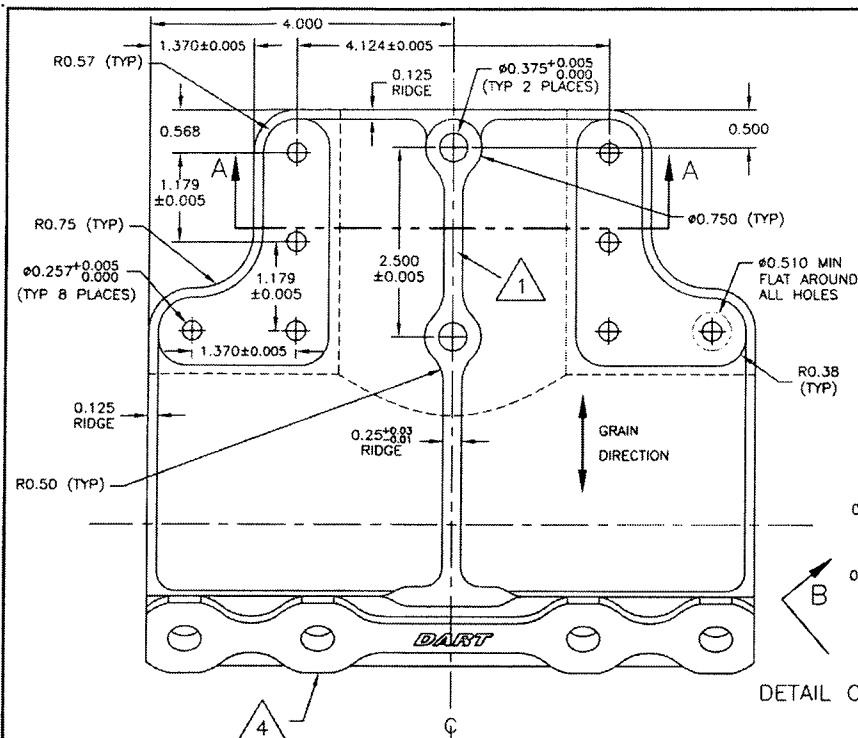
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

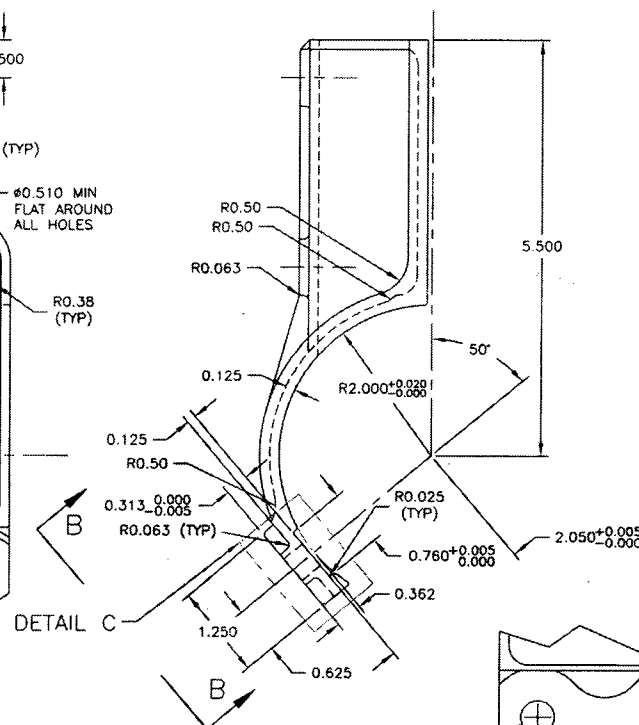
NOTE: Date & initial all entries

RELEASED

05.12.06



SECTION A-A



DETAIL C

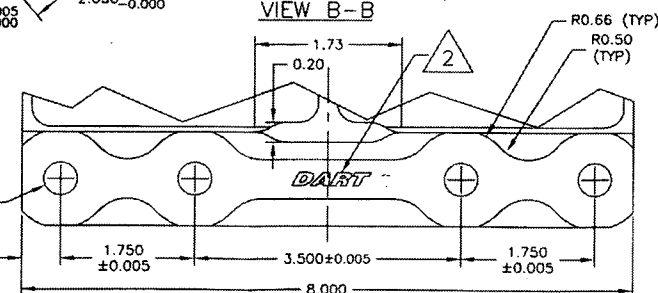
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	02573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
		SCALE			2:3

SUBJECT
WITH
W/
NO. 79717 M.L.5
12/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	79717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.439	.441	.441	.441		
B	1.745	1.755		1.752	1.750	1.750	1.750		
C	3.495	3.505		3.498	3.500	3.500	3.500		
D	1.745	1.755		1.752	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.004	8.004	8.004		
F	0.490	0.510		.500	.504	.504	.504		
G	0.257	0.262	2525-4	.257	.258	.258	.258		
H	0.375	0.380	85-4	.376	.377	.377	.377		
I	0.490	0.510		.5025	.503	.507	.503		
J	1.174	1.184	85-4	1.177	1.179	1.178	1.178		
K	0.558	0.578		.567	.569	.568	.568		
L	1.174	1.184		1.177	1.177	1.179	1.178		
M	1.365	1.375	85-4	1.369	1.369	1.369	1.369		
N	2.495	2.505	85-4	2.498	2.500	2.499	2.499		
O	4.119	4.129	85-4	4.122	4.124	4.122	4.122		
P	0.115	0.135	85-1	.126	.1247	.1232	.125		
Q	0.115	0.135		.129	.129	.130	.130		
R	0.240	0.260	85-1	.258	.254	.254	.254		
S	0.115	0.135		.126	.125	.125	.125		
T	0.178	0.198	rod gauge	.188	.188	.188	.188		
U	3.210	3.250	85-4	3.224	3.227	3.226	3.225		
V	0.230	0.250		.240	.241	.240	.237		
W	0.115	0.135		.125	.123	.125	.125		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.252	.250	.250		
AE	1.500	1.520	HARS 2	1.516	1.514	1.513	1.514		
AF	0.115	0.135		.119	.128	.135	.135		
AG	0.240	0.280	85-4	.261	.269	.271	.267		
AH	0.240	0.260		.249	.251	.251	.251		
AI	2.000	2.020	HARS-2	2.006	2.0048	2.0045	2.002		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	85
Date:	12/03/04

Audited by:	85
Date:	12/03/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	79717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.001	8.003		
F	0.490	0.510		.501	.501	.500	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.503	.501	.501		
J	1.174	1.184		1.174	1.174	1.174	1.174		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.174	1.174	1.174	1.174		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.124	.124	.126	.124		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.253	.256	.254	.253		
S	0.115	0.135		.125	.125	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.238	.238	.237	.237		
W	0.115	0.135		.123	.123	.123	.123		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.516	1.514	1.517	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.251	.254	.247	.247		
AI	2.000	2.020		2.003	2.002	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	21 12-03-04
Date:	

Audited by:	OMZ
Date:	12/03/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	79717
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	211	212		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.004		
F	0.490	0.510		.498	.504	.502	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.499	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.565	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.123	.125	.123	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.252	.254	.252	.253		
S	0.115	0.135		.123	.124	.130	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.237	.237	.239	.236		
W	0.115	0.135		.122	.123	.129	.124		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.362	.366	.365		
AA	0.470	0.530		.560	.500	.500	.500		
AB	0.615	0.635		.624	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.247	.252	.249		
AE	1.500	1.520		1.513	1.518	1.517	1.514		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.249	.250	.247		
AI	2.000	2.020		2.006	2.007	2.006	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RT
Date:	12-03-04

Audited by:	OK
Date:	12/03/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

